

DRILL JIGS

are operated by the usual screw and ball-crank combination. These screws are merely employed for making approximate settings; the actual locations which are depended upon to secure accurate spacing of the holes are made by means of micrometer heads and standard distance bars. The work-table is adjusted until both micrometers read zero against stops on the table which act as the micrometer anvils, and in this

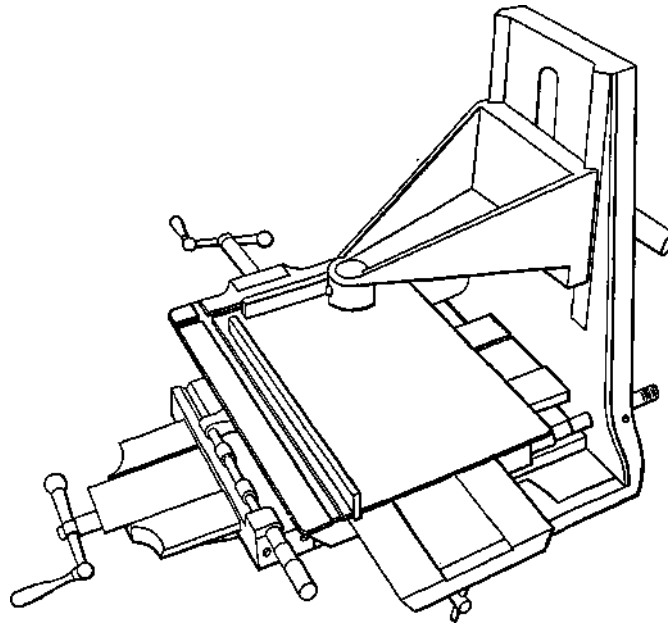


Fig. 27. Universal Jig which is in the Form of an Attachment for Drilling Machine

position the center of the drill bushing is located over the intersection of the guide strips on the work-table. The work is clamped against these guides, and in starting to locate the first hole, the two table slides are manipulated so that an approximate setting is secured, after which the distance bars and micrometer heads are used to obtain the final location in the manner to which reference has already been made. The arm which supports the drill bushing should be set to bring the bushing as close to the work as possible. It is possible to use this equip-